

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011652**Date Inspected:** 12-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr. Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

This CALTRANS Office of Structural Materials(OSM) Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG TRIAL ASSEMBLY**

This QA inspector performed dimensional check along with ABF on OBG skin plate flatness across transverse splice on below segments and readings found to be in general compliance.

6AE-6BE

6BE-6CE

6AW-6BW

This QA Inspector observed the following work in progress:

SEGMENT:6CE

Flux Cored Arc Welding (FCAW) welding of weld joint SEG032F-013. Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2233-TC-U4b-F.

SEGMENT:6AW

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## WELDING INSPECTION REPORT

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Shielded Metal Arc Welding (SMAW) welding of weld joint OBW6F-001. Welder is identified as 066261/037743. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2214-B-U2-FCM-1.

### SEGMENT:CB6

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG028H-054. Welder is identified as 069896. ZPMC Certified Welding Inspector (CWI) is identified as Mr. Wuzhi Chang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2214-1.

### SEGMENT:7CE (Bike Path Cantilever Beams)

This QA inspector observed, Heat Straightening of weld joint identified as 7CE-BK1-027 & 7CE-BK1-028 ZPM QC is identified as Wang Li Yang. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8080.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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